

Work Order ID 138584

Tuesday, November 03, 2015 11:44:30 AM

138584

Page 1

Item ID: D4811-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pin, Quick Release
Start Date: 11/3/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 11/3/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: MCS Date: NOV 03 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4811	A

100 PURCHASING 0.00
100
Purchasing Memo 0.00
Purchasing Issue P/O: 30366
Possible Supplier: McMaster Carr
Supplier p/n: 98470A133
Material release note is required

CY NOV 04 2015 10

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
Packaging Memo 0.00
Packaging Ensure Material Release Note is attached

10X 8015-11-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 138584***138584***

Page 2

Tuesday, November 03, 2015 11:44:30 AM

Item ID: D4811-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pin, Quick Release
Start Date: 11/3/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 11/3/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									DAS
QC	Memo	0.00							38
Quality Control									9-89
									NOV 09 2015
130	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
130									DAS
Packaging	Memo	0.00							27
Packaging									9-89
									NOV 09 2015
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

SU 0151109

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐		Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐		Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐		Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐		Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐		Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐		Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐		Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐		Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐		Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____ _____ _____			
Misidentified ☐	☐	Past Due ☐					

Picklist Print

Tuesday, November 03, 2015 11:44:34 AM

Page 1

Work Order ID: 138584

138584

Parent Item: D4811-1

D4811-1

Parent Item Name: Pin, Quick Release

Start Date: 11/3/2015

Required Date: 11/3/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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98470A133	Purchased	No	110	Each	0.0000	1	10
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98470A133

Pin, Quick Release

**

10x sp 15-10-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

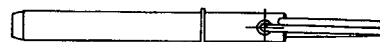
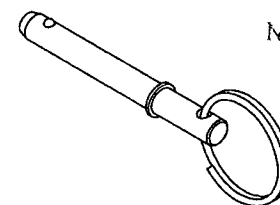
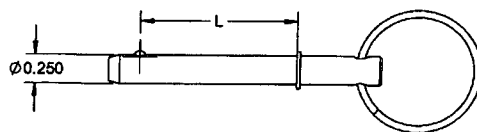
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS																																																													
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Misidentified ☐	Past Due ☐																																																																

SPECIFICATION CONTROL DRAWING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A CHANGE
WITHOUT NOTICE
WORK ORDER
NO. 138584 MJS
15-1103



DART PART NUMBER	DESCRIPTION	POSSIBLE VENDOR	VENDOR PART NUMBER	L	MATERIAL
D4811-1	QUICK RELEASE PIN	MCMaster CARR	98470A133	1.347	18-8 SS

RELEASED
2013-05-16
MP

NOTES:

- 1) MATERIAL: PER TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 METHOD 6.7
- 7) WEIGHT: N/A

A	NEW ISSUE	DB	13.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	MP	D4811	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	QUICK RELEASE PIN	NTS
DATE	13.04.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30366**

Purchase Order Date 11/4/2015

PO Print Date 11/4/2015

Page Number 1 of 6

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To :

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	98470A133 AS PER DWG D4811 REV. A B138584	Pin, Quick Release	11/6/2015 Yes 11/6/2015		10.00 Each	\$3.01	\$30.10
Line Total:							\$30.10
2	9928K53 AS PER DWG D4287 REV. A B138585	UHMW U-Channel	11/6/2015 Yes 11/6/2015		40.00 f	\$2.28	\$91.20
Line Total:							\$91.20
3	8672K31 AS PER DWG D4287 REV. A B138583	UHMW U-Channel	11/6/2015 Yes 11/6/2015		40.00 f	\$3.26	\$130.40

Note:

11/4/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Jean-Luc
Eric L

Purchase Order
PO30366
Order Placed By
Chantal Lavoie
McMaster-Carr Number
2957619-03

Page 1 of 1
11/04/2015

Line	Product	Ordered	Shipped
1	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length	10 Each	10
4	2841A61 Carbide Small-Diameter Drill Bit with 1/8" Shank, #58, 1-1/2" Overall Length, .39" Drill Depth	5 Each	5
5	7077A38 1/4" Shank-Mount Light Cleaning Brush, for Stainless Steel and Aluminum, 3" Brush Diameter, 0.010" Bristle Diameter	6 Each	6
6	6383K47 Steel Ball Bearing, Plain Open for 5/8" Shaft Diameter, 1-1/2" OD, 7/16" W	6 Each	6
7	6383K57 Steel Ball Bearing, Plain Open for 1" Shaft Diameter, 2" OD, 1/2" Width	4 Each	4
8	2737T9 Finished-Bore Sprocket for ANSI Roller Chain, for #25 Chain, 1/4" Pitch, 17 Teeth, 1/4" Bore	3 Each	3
9	6793K22 Steel Machinable-Bore Sprocket, for ANSI No. 25 Roller Chain, 1/4" Pitch, 45 Teeth	2 Each	2
10	98535A440 Spring Steel Standard Key Stock, 3/16" X 3/16", 36" Length	1 Each	1
11	6261K171 Roller Chain, ANSI No. 25, 1/4" Pitch, 3' Long	2 Each	2
12	6261K108 Connecting Link for ANSI No. 25, Roller Chain	2 Each	2
13	57545K427 10 Pitch Worm for 14-1/2 Degree Pressure Angle, Speed-Reducing Worm Gear for 90 Degree Transfer	1 Each	1
14	57545K424 Speed-Reducing Worm Gear for 90 Degree Transfer, 14-1/2 Degree Pressure Angle, Iron, 10 Pitch, 100 Teeth	1 Each	1

Shipped separately from our Chicago warehouse on 11/04

2	9928K53 Impact-Resistant UHMW Polyethylene U-Channel, 1" Base X 3/4" Legs, 1/4" Thick	40 Feet	40
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Expected to ship

15	5990K122 Base-Mount AC Motor, 115/208-230V AC, NEMA 56, 1/3 hp, Automatic Overload	1 Each	1 to ship by 11/18
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McMaster-Carr Supply Company
 700 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 42808002
 Purchase Order: PO30366
 Release:
 McMaster-Carr Number: 2957619-03

ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Ultimate Destination:
 Dart Aerospace Ltd
 1270 Aberdeen St
 Hawkesbury ON K6A 1K7
 Canada

Shipped: 04-Nov-2015 FOB: ORIGIN
 Shipper's Export Declaration (SED):
 NO EEI 30.36

Intermediate Consignee:

Bill To:
 Dart Aerospace Ltd
 1270 Aberdeen St
 Hawkesbury ON K6A 1K7
 Canada

Tax Number:

Forwarding Agent:

Billing
 Attention:
 Shipping Jean-Luc
 Attention: Eric L
 Contact:

Line	Description	Qty & Unit	Unit Price	Extension
1	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length Country of Origin: United States Schedule B #: 731829 ECCN #: EAR99 NLR	10 EA	\$3.01	\$30.10
4	2841A61 Carbide Small-Diameter Drill Bit with 1/8" Shank, #58, 1-1/2" Overall Length, .39" Drill Depth Country of Origin: Taiwan Schedule B #: 820750 ECCN #: EAR99 NLR	5 EA	\$4.51	\$22.55
5	7077A38 1/4" Shank-Mount Light Cleaning Brush, for Stainless Steel and Aluminum, 3" Brush Diameter, 0.010" Bristle Diameter Country of Origin: United States Schedule B #: 960350 ECCN #: EAR99 NLR	6 EA	\$17.52	\$105.12
6	6383K47 Steel Ball Bearing, Plain Open for 5/8" Shaft Diameter, 1-1/2" OD, 7/16" W Country of Origin: United States Schedule B #: 848210 ECCN #: 1C999 NLR	6 EA	\$6.74	\$40.44
7	6383K57 Steel Ball Bearing, Plain Open for 1" Shaft Diameter, 2" OD, 1/2" Width Country of Origin: United States Schedule B #: 848210 ECCN #: 1C999 NLR	4 EA	\$12.04	\$48.16
Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.				
These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.				

Shipping Weight (in kgs): 10

Number of Packages: 1

Package Dimensions:

97 X 31 X 33 CM = .101 CUBIC M

Invoice Amounts:

Merchandise Amount: \$617.42
 Canadian GST/HST: \$82.98
 Shipping Charges: \$20.82
 Total (In USD): \$721.22

Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days

Authorized Signature:

Sarah Weinberg

Date:

04-Nov-2015

Remit payment to:

(by mail)
 McMaster-Carr Supply Company
 PO Box 7690
 Chicago, IL 60680-7690 USA

(by wire transfer)

Bank of America Illinois
 231 S LaSalle
 Chicago, IL 60697
 ABA 071000039 Account 86666-02021
 SWIFT BOFAUS3N

Name: Sarah Weinberg

Title: Operations Mgr.

Page 1 of 2

McMaster-Carr Supply Company
 200 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 42808002
 Purchase Order: PO30366
 Release:
 McMaster-Carr Number: 2957619-03

ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
8	2737T9 Finished-Bore Sprocket for ANSI Roller Chain, for #25 Chain, 1/4" Pitch, 17 Teeth, 1/4" Bore Country of Origin: United States Schedule B #: 848390 ECCN #: EAR99 NLR	3 EA	\$10.63	\$31.89
9	6793K22 Steel Machinable-Bore Sprocket, for ANSI No. 25 Roller Chain, 1/4" Pitch, 45 Teeth Country of Origin: United States Schedule B #: 848390 ECCN #: EAR99 NLR	2 EA	\$29.39	\$58.78
10	98535A440 Spring Steel Standard Key Stock, 3/16" X 3/16", 36" Length Country of Origin: United States Schedule B #: 731824 ECCN #: EAR99 NLR	1 EA	\$8.31	\$8.31
11	6261K171 Roller Chain, ANSI No. 25, 1/4" Pitch, 3' Long Country of Origin: Japan Schedule B #: 731511 ECCN #: EAR99 NLR	2 EA	\$15.42	\$30.84
12	6261K108 Connecting Link for ANSI No. 25, Roller Chain Country of Origin: Japan Schedule B #: 731519 ECCN #: EAR99 NLR	2 EA	\$1.00	\$2.00
13	57545K427 10 Pitch Worm for 14-1/2 Degree Pressure Angle, Speed-Reducing Worm Gear for 90 Degree Transfer Country of Origin: United States Schedule B #: 848340 ECCN #: EAR99 NLR	1 EA	\$43.13	\$43.13
14	57545K424 Speed-Reducing Worm Gear for 90 Degree Transfer, 14-1/2 Degree Pressure Angle, Iron, 10 Pitch, 100 Teeth Country of Origin: United States Schedule B #: 848340 ECCN #: EAR99 NLR	1 EA	\$196.10	\$196.10
	NOTE Tracking number(s) for this shipment: MFA004500151			

Number of Packages: 1

Page 2 of 2